



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3571-1

Job Sheet 177189



Part No: D3571-1

Job Qty: 16 ea

Part Name: Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-02-01 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea	6/18/18	6/18/18	0.00	0.00	Start Up Machining-2		<i>[Signature]</i> DAS
100	Bandsaw	16 pcs	6/18/18	6/18/18	0.00	0.30	Bandsaw1		<i>[Signature]</i> 54
110	CNC Vertical Machining	16 pcs	6/18/18	6/18/18	0.40	10.81	HAAS1-4		<i>[Signature]</i> 9-89
120	QC	16 pcs	6/18/18	6/18/18	0.00	0.00	QC2 Machining-2		<i>[Signature]</i>
130	QC	16 pcs	6/18/18	6/18/18	0.00	0.00	QC8 Machining-2		<i>[Signature]</i>
140	HandFinish	16 pcs	6/18/18	6/18/18	0.00	0.45	HandFinish1		<i>[Signature]</i> 18-06-01
150	Powdercoat	16 pcs	6/18/18	6/18/18	0.00	0.32	Powdercoat3		<i>[Signature]</i> 18-06-01
160	QC	16 pcs	6/18/18	6/18/18	0.00	0.00	QC3		<i>[Signature]</i> 11 JUN 07 2018
170	Packaging	16 pcs	6/18/18	6/18/18	0.00	0.00	Packaging3-1		<i>[Signature]</i> 9-89
180	QC21-SA	16 Ea	6/18/18	6/18/18	0.00	0.00	QC21		<i>[Signature]</i> DAS

Part Op 100 - Cut blank 2.90 " long

Descriptions: 110 - 1- Mill as per Folio FA675Rev: _____ & Dwg D3571 Rev: _____ 2-Deburr per dwg D3571

150 - START TIME: 11:00 OJT 300° FINISH: 11:30 M136320

21 JUN 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	3.8560 ft (.241 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X01.500	4	17	0

Part Specifications

Specifications could not be found.

Plex 5/8/18 10:28 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Not Approved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																							
Date :	Part: D3571-1 Job No: 177189 Serial No/Batch: S076661 Revision: Inspector: Exp Date: 05/31/2018 Instructions: DATE: 05/31/18																																																																																																								
Descript 	DART AEROSPACE Container No: S076661 1419 Audrean Ave. Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 652-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																																																								
				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td colspan="5" style="text-align: center;">Root Cause</td> </tr> <tr> <td style="width:15%;">Environment</td> <td>☐</td> <td style="width:15%;">No Re</td> <td>☐</td> <td style="width:15%;">Loss/Surge</td> <td>☐</td> <td style="width:15%;">Positioned Wrong</td> <td>☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Oper</td> <td>☐</td> <td>Program</td> <td>☐</td> <td>Outside Dimensions</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offse,</td> <td>☐</td> <td></td> <td>☐</td> <td>Over/Under tolerance</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>Part Incorrect</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td>Part Lost/Missing</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Part Moved</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Turning Sequence</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td>☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td colspan="4" style="text-align: center;">OTHER :</td> </tr> </table>					Root Cause					Environment	☐	No Re	☐	Loss/Surge	☐	Positioned Wrong	☐	Design	☐	Oper	☐	Program	☐	Outside Dimensions	☐	Doc/Data	☐	Offse,	☐		☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐		☐			Misidentified	☐	Past Due	☐	OTHER :			
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DART AEROSPACE LTD		Work Order: 177189
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.698	/			
Ø1.00 Depth 100	+/-0.010	1.000 x 0.099	/			
2.75	+/-0.030	2.753	/			
1.38	+/-0.030	1.377	/			
1.25	+/-0.030	1.246	/			
0.63	+/-0.010	0.628	/			
0.031 chamfer	+/-0.010	0.032	/			
Ø0.500	+0.006/-0.001	0.500	/			
Ø0.201	+0.005/-0.001	0.202	/			
R0.25	+/-0.030	R0.25	/			
0.260	+0.000/-0.010	0.255	/			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	0.385 x 100°	/			
0.125	+/-0.010	0.125	/			
2.250	+/-0.010	2.240	/			
0.250	+/-0.010	0.252	/			
0.188	+/-0.010	0.188	/			
0.063 chamfer	+/-0.010	0.063	/			

DAS
54

Measured by: 9-89	Audited by: [Signature]	Prototype Approval: N/A
Date: 18/05/31	Date: 18/05/31	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					